

Work Order ID 135869

August 21, 2015 2:56:27 PM

135869

Page 1

For order to ship Sept 4/15.

Item ID: K591-113

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Short Step Instln

Stop

NS2

Start Date: 8/21/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/2/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date: 0150821

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI9525

A

DAS
6
9-89

MS 15-08-28

104

Pick Kit

0.00

104

Packaging

Memo

0.00

DAS
6
9-89

4

AUG 24 2015

DAS
02
9-89

Packaging

105

QC4- 100% Inspect kits for completeness

0.00

105

QC

Memo

0.00

4

EB

15-08-31

Quality Control

110

Identify as per dwg & Stock Location:

PK 15 A

0.00

110

Packaging

Memo

0.00

CHG005

4

DAS
02
9-89

15-08-31

Packaging

AUG 31 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

August 21, 2015 2:56:27 PM

Page 2

SA 20150901

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

August 21, 2015 2:56:35 PM

Page 1

Work Order ID: 135869

135869

Parent Item: K591-113

K591-113

Parent Item Name: Short Step Instln

Start Date: 8/21/2015

Required Date: 9/2/2015

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP : C04.11.09ReformatKJ/JLM
as per revG DD 10.04.20 verified by:EC
586 10.06.18 DD verf:EC

IPP Rev:D
IPP Rev:E as per ECN10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2171 Clamp	DAS 38 9-89	Manufactured	No			104	Each	23.0000	2	8			
**												DAS 6 9-89	DAS 02 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST542		23							
				132796		23							
D2274 Radius Block	DAS 38 9-89	Manufactured	No			104	Each	67.0000	4	16			
**													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		12							
				86855		12							
				ST		24							
				110264		24							
				ST006		31							
				127579		11							
				131031		20							

Picklist Print

August 21, 2015 2:56:35 PM

Page 2

Work Order ID: 135869

135869

Parent Item: K591-113

K591-113

Parent Item Name: Short Step Instln

Start Date: 8/21/2015

Required Date: 9/2/2015

Start Qty: 4.00

Required Qty: 4.00

D2182B Manufactured No 104 f 695.5880 0.5833 2.3332

D2182B

Rubber Cushion - Black (\$Per Foot)

DAS
38
9-89

Location

Loc Qty

Loc Code

ST411	389.378	
108914	1.5	
115189	21.5	
128976	16.378	
135093	350	
st640	306.21	
130427	306.21	

68-6
9
SVD

DAS
02
9-89

(D2182B035) CUT 2 AT 3.50"

D2362-3

Manufactured No

104 Each

6.0000

1

4

D2362-3

Step Support Bracket

DAS
38
9-89

Location

Loc Qty

Loc Code

ST537	6	
133861	6	

**

DAS
6
9-89

DAS
02
9-89

D3595-200-300

Manufactured No

104 Each

42.0000

1

4

D3595-200-300

Rubber Cushion 2.00" wide x 3.00" Long

DAS
38
9-89

Location

Loc Qty

Loc Code

FG	5	
84209	5	
ST419	37	
130665	37	

**

DAS
6
9-89 DAS
02
9-89

AUG 24 2015

Picklist Print

August 21, 2015 2:56:35 PM

Page 3

Work Order ID: 135869

Parent Item: K591-113

Parent Item Name: Short Step Instln

135869

K591-113

Start Date: 8/21/2015

Required Date: 9/2/2015

Start Qty: 4.00

Required Qty: 4.00

AN3-37A

Purchased

No

104

Each

35.0000

2

8

AN3-37A

Bolt

DAS
38
9-89

**

DAS
6
9-89

02
9-89

Location

Loc Qty

Loc Code

FG

10

119086

10

FP001

14

m130325

14

ST347

11

m130466

11

AN4-21A

Purchased

No

104

Each

98.0000

4

16

AN4-21A

Bolt

DAS
38
9-89

**

DAS
02
9-89

Location

Loc Qty

Loc Code

ST342

98

m132716

98

AN4-22A

Purchased

No

104

Each

199.0000

1

4

AN4-22A

Bolt

38
9-89

**

DAS
6
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

GA

50

116419

50

ST342

149

123348

100

m128403

49

7

Picklist Print

August 21, 2015 2:56:36 PM

Page 4

Work Order ID: 135869

135869

Parent Item: K591-113

K591-113

Parent Item Name: Short Step Instln

Start Date: 8/21/2015

Required Date: 9/2/2015

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0363J

Purchased

No

104

Each

1,021.000

4

16

NAS1149D0363.J

DAS

38

Washer

9-89

Location

Loc Qty

Loc Code

CA

246

m130799

246

GA

323

m130799

323

ST269

452

m126319

7

m131618

1

m132317

108

m132677

336

DAS

6

9-89

DAS

02

9-89

NAS1149D0463J

Purchased

No

104

Each

2,736.000

6

24

NAS1149D0463.J

DAS

38

WASHER

9-89

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST260a

1000

M132677

1000

ST269

1695

M127904

20

M129682

86

M130799

371

M132035

1093

M132317

125

DAS

6

9-89

DAS

02

9-89

AUG 24 2015

Picklist Print

August 21, 2015 2:56:36 PM

Page 5

Work Order ID: 135869

135869

Parent Item: K591-113

K591-113

Parent Item Name: Short Step Instln

Start Date: 8/21/2015

Required Date: 9/2/2015

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

104

Each

1,305.000

2

8

MS21042L3

Nut

DAS
38
9-89

Location

Loc Qty

Loc Code

FP001

384

M130922

384

GA

264

M131317

264

ST305

657

116549

12

126333

49

M128754

2

M132123

17

M132382

2

M132883

75

M132930

500

DAS
6
9-89

AUG 24 2015

DAS
02
9-89

5

Picklist Print

August 21, 2015 2:56:36 PM

Work Order ID: 135869

135869

Parent Item: K591-113

K591-113

Parent Item Name: Short Step Instln

Start Date: 8/21/2015

Required Date: 9/2/2015

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

104

Each

2,564.000

5

20

DAS

6

9-89

MS21042L 4

**

Locknut

DAS

38

9-89

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

124

m127813

124

ST260a

170

m130799

56

m131803

6

m132262

108

ST305

2268

m128300

8

m128798

12

m130388

7

m130922

97

m131618

12

m132123

56

m132382

2076

12

8

AUG 24 2015

DAS

02

9-89

For order to ship Sept 4/15

Work Order ID 135869

135869

Page 1

August 21, 2015 2:56:27 PM

Item ID: K591-113

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Short Step Instln

Start Date: 8/21/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/2/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan: _____ Date: 20150821 Tooling: _____ Date: _____

Stop

NR2

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9525	A								
104	Pick Kit	0.00							
104									
Packaging	Memo	0.00							
Packaging									
105	QC4- 100% Inspect kits for completeness	0.00							
105									
QC	Memo	0.00							
Quality Control									
110	Identify as per dwg & Stock Location: _____	0.00							
110									
Packaging	Memo	0.00							
Packaging	***CHG005***								

DAS
6
2-89

MUS AUG 25 2015

DAS
8
2-89

4 AUG 24 2015

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3

REF TCCA STC: SH92-6
REF FAA STC: SH967NE

PURPOSE:

TO PROVIDE AN OPTIONAL CUSHION KIT TO BE INSTALLED ON THE D350-591-111A/-113/-115/-117A/-119 *Heli-Access-Step™* (THE D2856-400-720 ABRASION STRIP IS REPLACED WITH THE D3595-200-300 CUSHION).

CHANGE:

FOR D350-591-111A/-113/-115 @ CHG 005 (OR LATER), D350-591-117A @ CHG 003 (OR LATER) AND D350-591-119 @ CHG 004 (OR LATER), THE PARTS LIST OF INSTALLATION INSTRUCTIONS D350-591 AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 IS AMENDED AS FOLLOWS:

QTY -111A	QTY -113	QTY -115	QTY -117A	QTY -119	Part Number	Description
X					D350-591-111A	Heli-Access-Step™, Long Step – High Skid
	X				D350-591-113	Heli-Access-Step™, Short Step – High Skid
		X			D350-591-115	Heli-Access-Step™, Short Step – Low Skid
			X		D350-591-117A	Heli-Access-Step™, Pre-Flight Step
				X	D350-591-119	Heli-Access-Step™, Long Step – Low Skid
	1				D2310	STEP ASSEMBLY (HIGH-SHORT)
1					D2311	STEP ASSEMBLY (HIGH-LONG)
		1			D2354	STEP ASSEMBLY (LOW-SHORT)
				1	D2355	STEP ASSEMBLY (LOW-LONG)
4	2	2	2	2	D2171	CLAMP
4	2	2	2	2	D2182B035	CUSHION
8	4	4	4	4	D2274	RADIUS BLOCK
			1		D2362-041	SUPPORT BRACKET
2	1			1	D2362-3	SUPPORT BRACKET
		1			D2362-5	SUPPORT BRACKET
2	1	1	1	1	D3595-200-300	CUSHION (NEW)
2	2	2		2	AN3-37A	BOLT
		4			AN4-20A	BOLT (REPLACED, WAS AN4-16A)
8	4			4	AN4-21A	BOLT (REPLACED, WAS AN4-20A)
1	1	1	4	1	AN4-22A	BOLT
4	4	4		4	NAS1149D0363J	WASHER (OR AN960JD10)
10	6	2	4	6	NAS1149D0463J	WASHER (OR AN960JD416)
		4			NAS1149D0416J	WASHER (OR AN960JD416L)
2	2	2		2	MS21042L3	NUT
9	5	5	4	5	MS21042L4	NUT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)
DATE: 10.06.08
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE.	JPH	10.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. REV. A	
MFG. APPR.	N/A	DSI 9525 SHEET 1 OF 4	
APPROVED		TITLE SCALE	
DE APPR.		STEP CUSHION CHANGE NTS	
DATE	10.06.08	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	